

ABSTRACT

A panel, such as a fence panel, is assembled by a projection welding process from a plurality of upright members and a plurality of rails. The rails and upright members are first assembled into a flat panel framework, which is introduced into a welding area having multiple welding stations arrayed in a series of rows. Paired welding stations in adjacent odd- and even-numbered rows are positioned on opposite sides of the panel framework. Each welding station is characterized by at least two laterally spaced electrodes of opposite polarity, both situated on the same side of the panel framework. One electrode contacts an underlying rail, while the other electrode contacts an underlying upright member. A welding current transmitted between the electrodes causes an internal weld to form between the upright member and the rail at a projection within the rail channel.